

Work Order ID 65666

Wednesday, February 23, 2011 1:07:46 PM

**DUPLICATE**

Page 1

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Beam Assembly

Stop



Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mk* Date: *11-02-23* Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4271	B
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100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

ES/02/28 ①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub/28

④

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*RM66324**64/3/01* ①

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Page 2

Wednesday, February 23, 2011 1:07:46 PM

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01 JJ

CL 11/03/01

Picklist Print

Wednesday, February 23, 2011 1:07:43 PM

Page 1

Work Order ID: 65666

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 1/21/2011





Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD

IPP RevA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5  Eyebolt Stud		Manufactured	No			100	Each	1.0000	1	1		EP 11/02/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST133				5		B 64213			
D4274-1  Plate, Fwd Support		Manufactured	No			100	Each	4.0000	2	2		EP 11/02/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
				65883				4					
D4275-1  Fwd Beam		Manufactured	No			100	Each	1.0000	1	1		EP 11/02/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				1					
				65670				1					
D4281-1  Spacer		Manufactured	No			100	Each	1.0000	1	1		EP 11/02/28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				1					
				63886				1		B 66705			

Picklist Print

Wednesday, February 23, 2011 1:07:44 PM

Page 2

Work Order ID: 65666

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

96.0000

6

8



Bolts

Location

Loc Qty

Loc Code

ST351

96

112314

8

114761

11

116022

2

116289

17

116786

8

116924

50



EP 11/02/28

MS20615-4M18

Purchased

No

100

Each

190.0000

8

8



Rivet

Location

Loc Qty

Loc Code

ST323

190

114808

128

115037

62



EP 11/02/28

MS21043-3

Purchased

No

100

Each

1,270.000

6

8



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1194

112314

1194



EP 11/02/28

Wednesday, February 23, 2011 1:07:44 PM

Shop Packet Print

Page 2

Picklist Print

Wednesday, February 23, 2011 1:07:44 PM

Page 3

Work Order ID: 65666

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 1/21/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

2,804.000

12

16



Washer



Ep 11/02/28

Location

Loc Qty

Loc Code

ST297

2804

115000

125

115698

35

116025

108

116304

2536

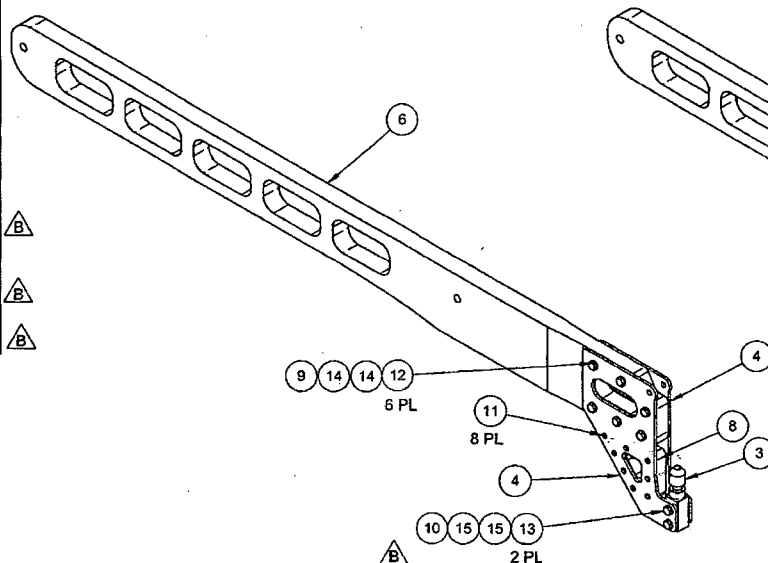
12

* M521043-4 QTY: 2 B# M116188 *Ep 11/02/28*

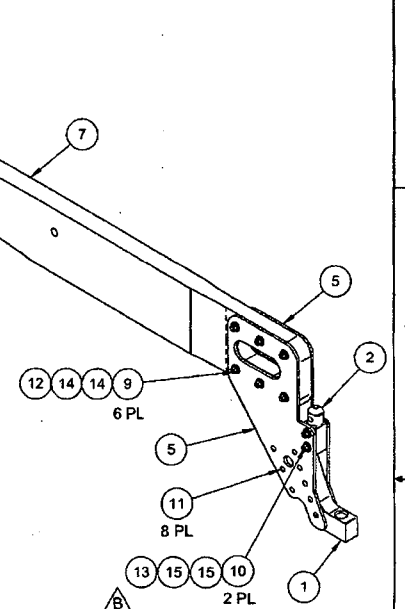
* NAS1149C0432R QTY: 4 B# M116900 *Ep 11/02/28*

* AN4C13A QTY: 2 B# M116914 *Ep 11/02/28*

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED
2010-12-06

#63000

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	#		
MFG. APPR.	#		
APPROVED	#		
DE APPR.	#		
DATE	10.12.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4271	REV. B
TITLE SUPPORT BEAM ASSEMBLIES	SCALE NTS
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